

Process Sheet

SPLIT- 2

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 45392 - 2  
Estimate Number : 10897  
P.O. Number :  
This Issue : 02/02/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : MACHINED PARTS  
Previous Run : 42169  
Written By :  
Checked & Approved By : NO 09 02 02  
Comment : Est Rev:F Re-format 05-11-22 JLM

Drawing Name : BUSHING

Part Number : D2618  
Drawing Number : D2618 REV B1  
Project Number : N/A  
Drawing Revision : B1  
Material : N/A  
Due Date : 12/02/2009

Qty: 300 Um: Each  
223 Q.

104  
104

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	MDELRLNR0750	Delrin Round Bar 0.75"
		Comment: Qty.: 0.2709 f(s)/Unit Total : 81.2700 f(s) Delrin Round Bar .75" black M110784 Batch: M109571
		1/4 09/02/17 200 09/02/04 (77)
		* NO MORE STOCK * NOT REMOVED FROM COMP. INV.
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA195 & Dwg D2618.
		2-Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		09/02/15/4 09/02/11 200 09/02/04 (77)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		09/02/23 09/02/06 (77)
		Comment: SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST39
		ST39 88 09/02/23 (77)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2618 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>45392</u> -2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/17 4	2.0	Holes off center $\pm .005$ , holes too small $.302 \rightarrow .313 \pm .000$ too small $3.100 \pm .010 \rightarrow 3.095$ RC → Programming errors previous shift 825 pcs scrap3	UP 09-02-23 P/C QSI 042	SCRAP QTY(10), DID NOT FIT ANS BOLT. REST ARE OK New prog Centro. OLD Prog is No AV.	UP 09/02/22 S Jn 09-02-22, 02/02/23 QSI 042		GP 09-02-23 P/C	S 09-02-23

NOTE: Date &amp; initial all entries

to:  
ser:

Monday, 02/02/2009 11:50:03 AM  
Julie Dawson

Customer: CU-DAR001 Dart Helicopters Services

# Process Sheet

Drawing Name: BUSHING

Job Number: 45392

Part Number: D2618

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE



09/02/24/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-09

DART AEROSPACE LTD	Work Order:	45392
Description: Bushings	Part Number:	D2618
Inspection Dwg:	Rev: B1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	4	Audited by:	pd	Prototype Approval:	N/A
Date:	09/02/17	Date:	09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	NS392
Description: Bushing	Part Number:	D2618
Inspection Dwg: D2618	Rev: B1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

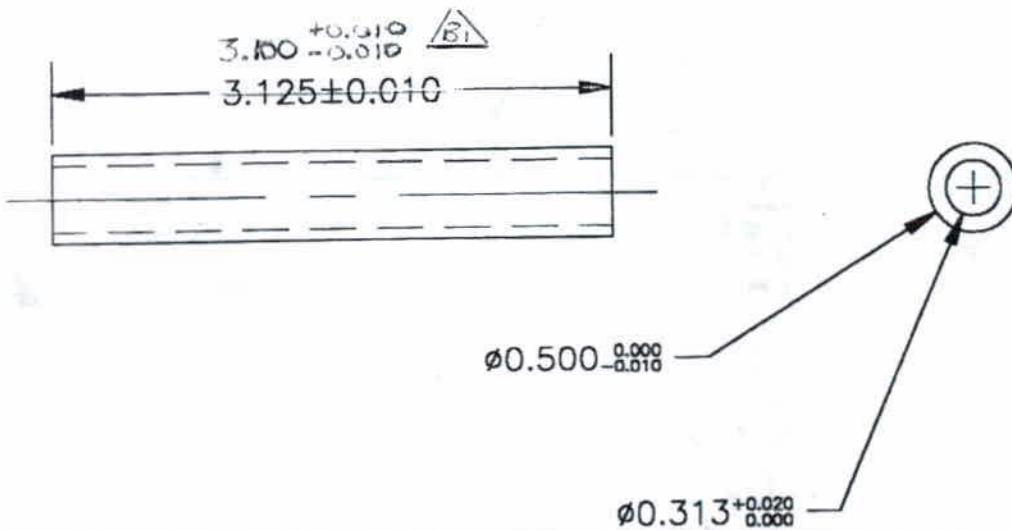
## X First Article      Prototype

Measured by:	4	Audited by:	SD	Prototype Approval:	N/A
Date:	09/02/04	Date:	09/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.26	New Issue	KJ/JLM	
B	04.09.10	Changed tolerance for Ø0.500	KJ/JLM	<i>[Signature]</i>

**DART**COPY  
DRAFT

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2618	REV. B SHEET 1 OF 1
DATE 96:10:30		TITLE BUSHING	SCALE 1:1
B	97.05.09	3.125 WAS 1.625, .313 WAS .375	
<i>01/06/03</i>		CHANGE DIM FOR BETTER FIT	

**RELEASED**  
97/05/13 DS

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NO. *HS3302*